

Date: Tuesday, 12/18/2007 10:51:25 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 36425	
Estimate Number : 12731	
P.O. Number : <i>N/A</i>	Part Number : D353535
This Issue : 12/18/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3535 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 36194	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 1/15/2008
Checked & Approved By : <i>[Signature]</i> 07.12.18	Qty: 20 Um: Each
Comment : Est Rev: New Issue 07-02-15 JLM	
Est Rev: B As per Rev B 07-08-31 JLM Verified By: EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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*21.8998*

Comment: Qty.: 0.8423 sf(s)/Unit Total : 16.8462 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: *106202 IB 8-1-7*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: *B IB 8-1-7*Prog Rev: *B**(26)*2-Deburr if necessary *IB 8-1-7*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*IB 8-1-7*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

counters 08/01/08 (26)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Deburr if necessary

2-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.

3-Identify as D3535-35.

SB 08/01/08 (26)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 08/01/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/18/2007 10:51:25 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 36425

Part Number: D353535

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/01/08 (x26)

7.0

POWDER COATING

POWDER COATING



M105642



(26X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-h 08/01/09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-09

(x26)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-17

YJ

08-01-09

(x26)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/11

Job Completion



12 08-01-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36425
Description: Wearshoe		Part Number:	D3535-35
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.000	✓			
1.885	+/-0.010	1.887	✓			
6.00	+/-0.030	6.00	✓			
6.75	+/-0.030	6.75	✓			
Ø0.188	+0.005/-0.001	.189	✓			
23.250	+/-0.010	23.250	✓			
19.750	+/-0.010	19.750	✓			
17.750	+/-0.010	17.750	✓			
14.250	+/-0.010	14.250	✓			
9.500	+/-0.010	9.500	✓			
4.750	+/-0.010	4.750	✓			
0.300	+/-0.010	.302	✓			
0.300	+/-0.010	.302	✓			
0.038	+/-0.010	.036	✓			

Measured by:	MB	Audited by:	J	Prototype Approval:	N/A
Date:	8-1-7	Date:	08/01/08	Date:	N/A

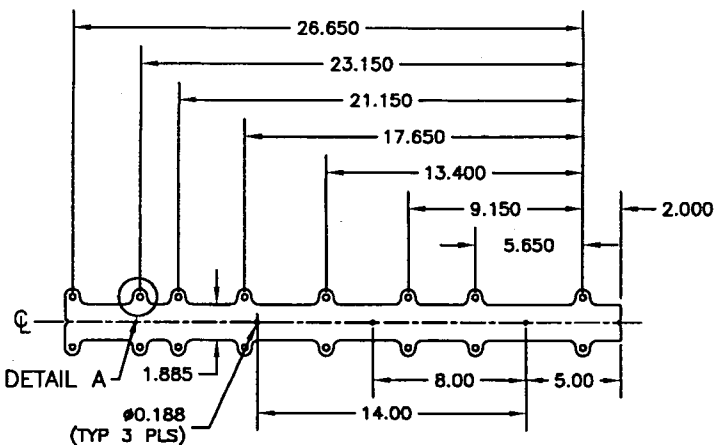
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	BE

DART

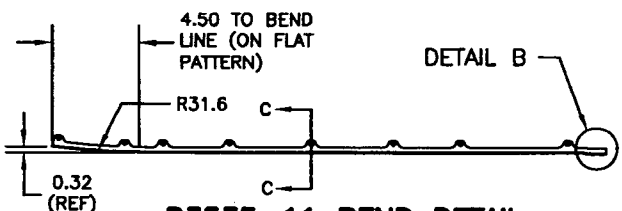
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07.04.24

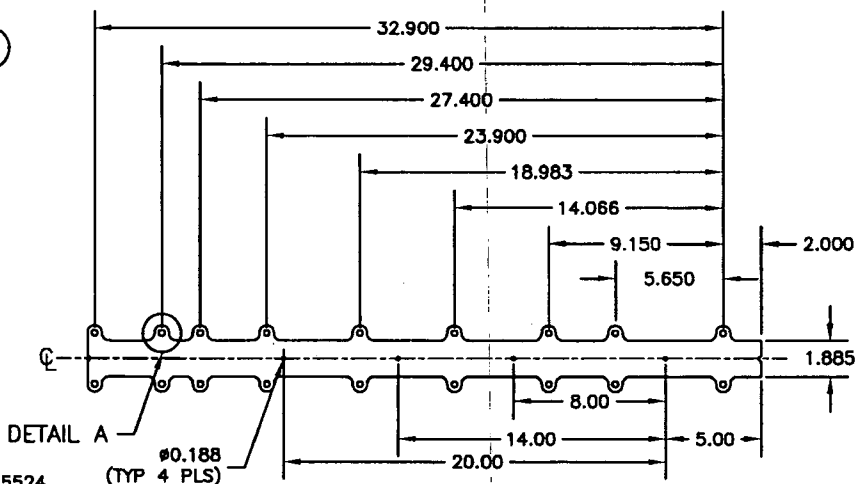
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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 1 OF 7
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC



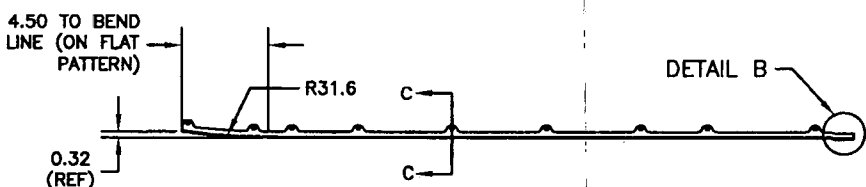
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

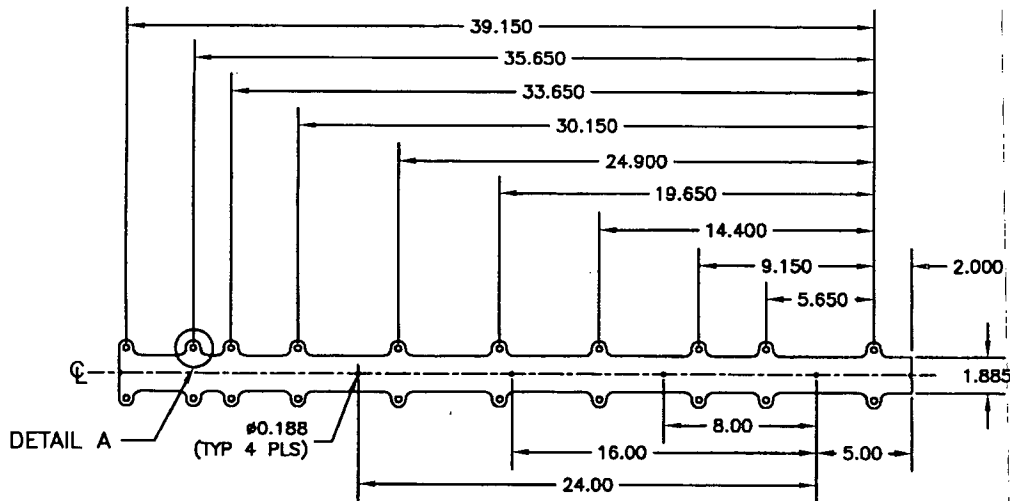
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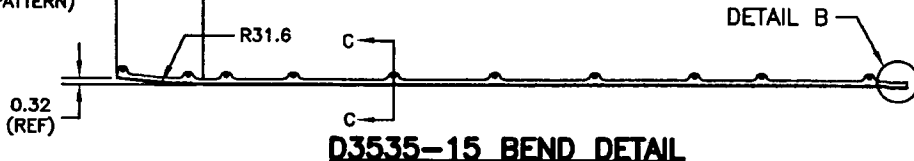
07.04.24

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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 7
<i>[Signature]</i>	<i>[Signature]</i>	D3535	
DATE	TITLE	WEARSHOE	SCALE
07.04.17			1:10

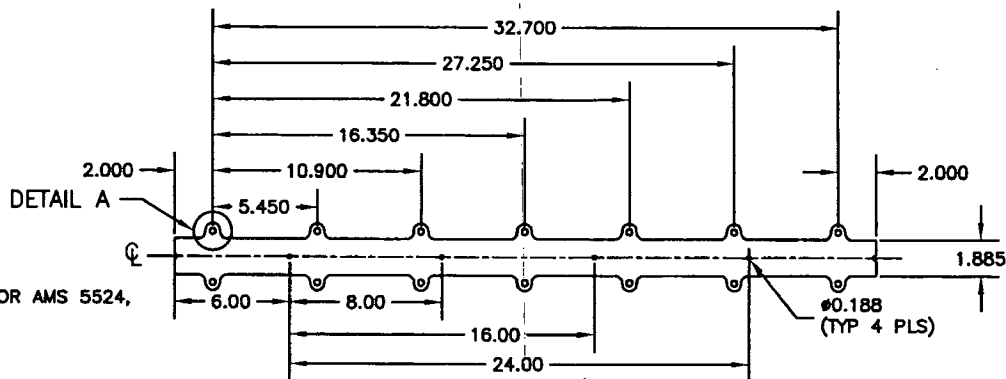


4.50 TO BEND
LINE (ON FLAT
PATTERN)

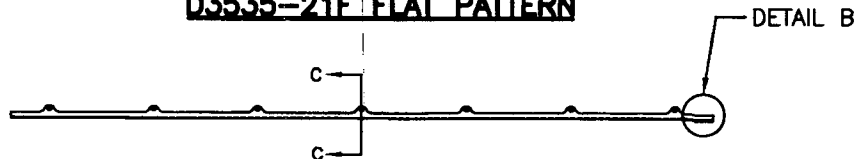
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
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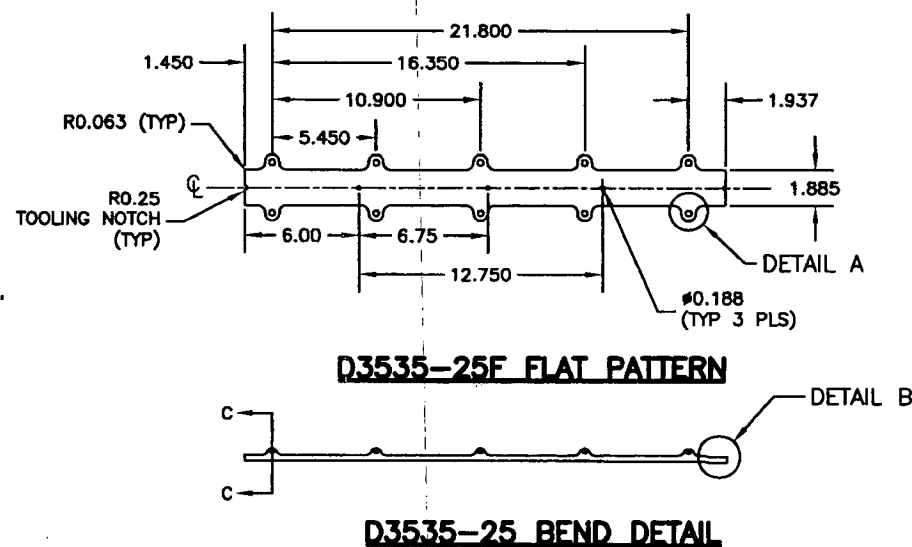
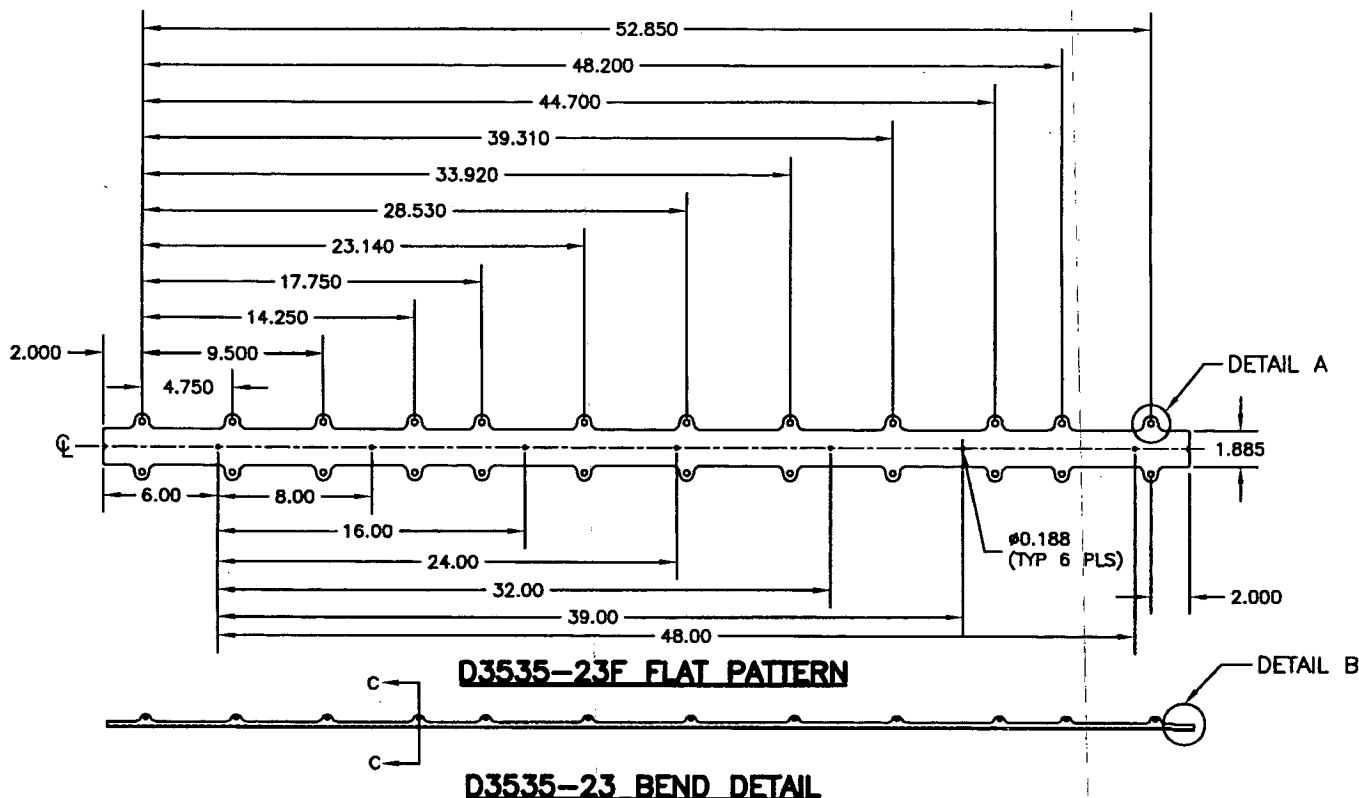
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CHECKED	APPROVED	DRAWING NO.	REV. B
#	#	D3535	SHEET 3 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:10

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07.04.24

**NOTES**

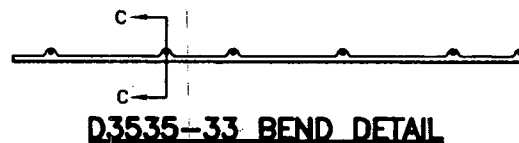
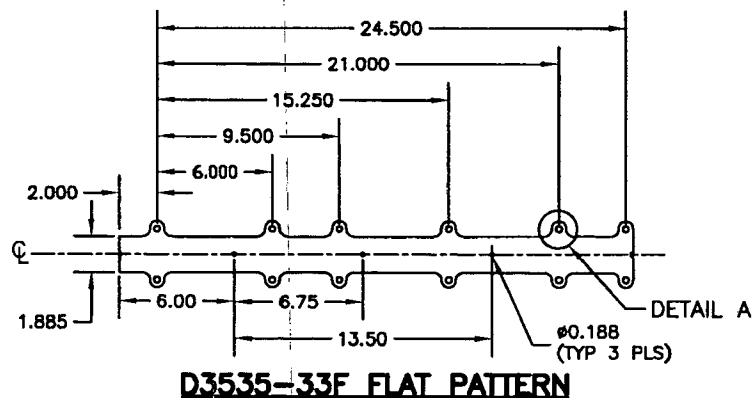
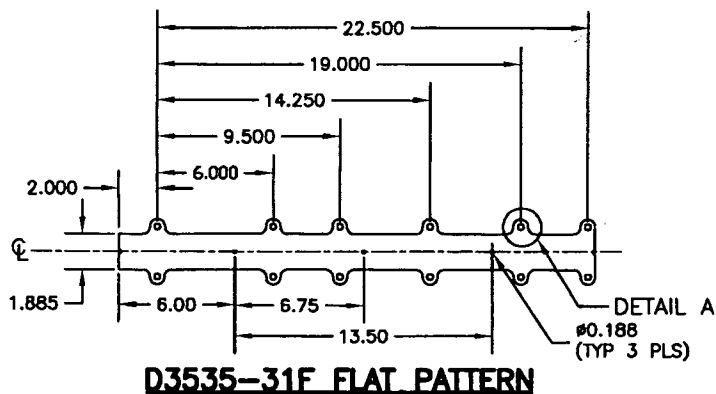
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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DATE	07.04.17	TITLE	WEARSHOE	REV. B SHEET 4 OF 7
		SCALE	1:10	



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NOTES

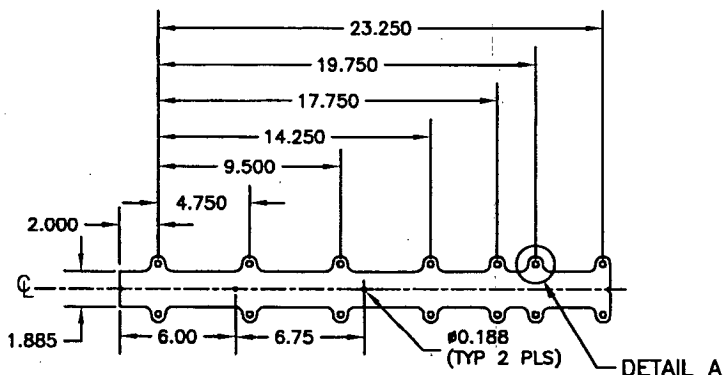
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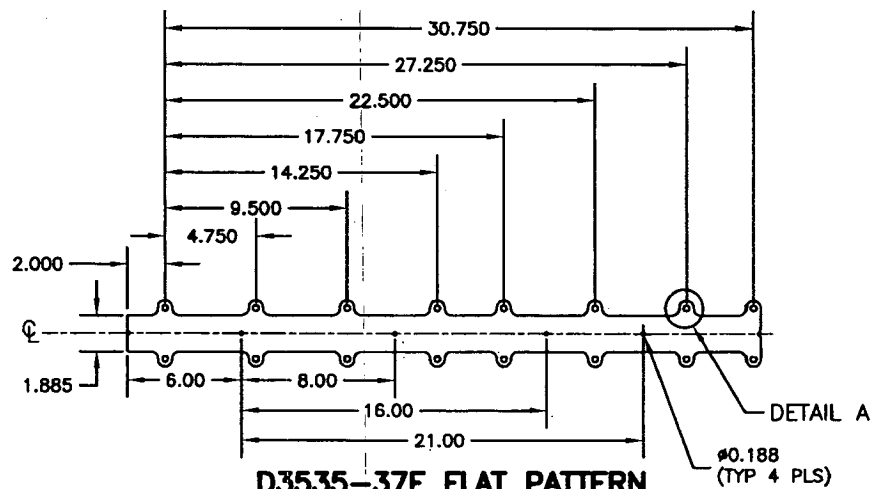
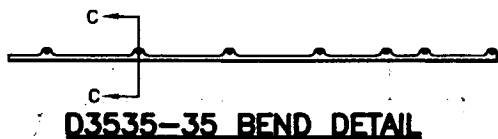
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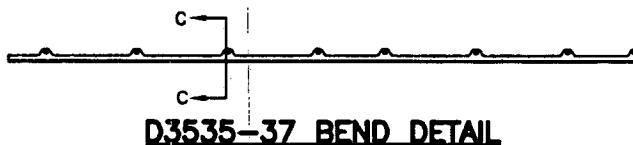
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 5 OF 7
		SCALE	1:10	



D3535-35F FLAT PATTERN



D3535-37F FLAT PATTERN



NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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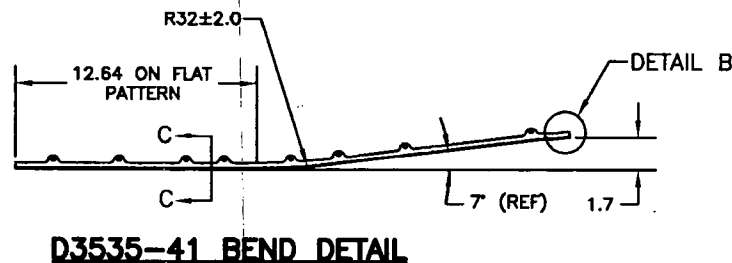
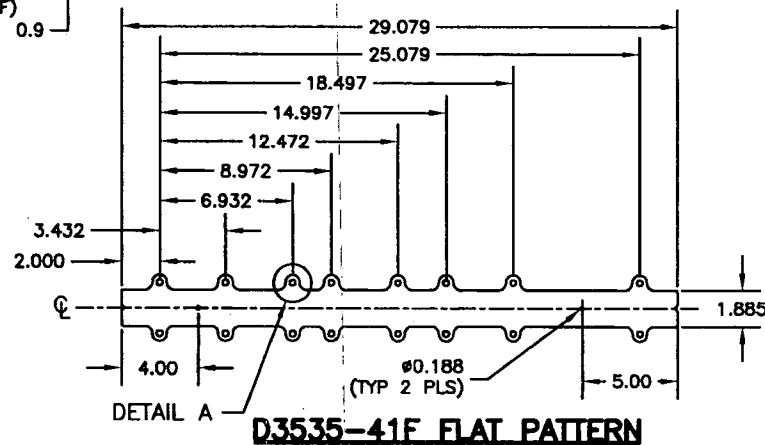
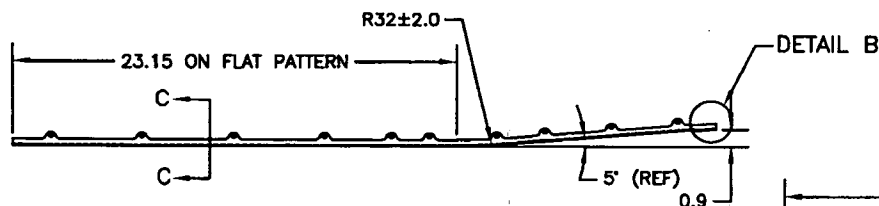
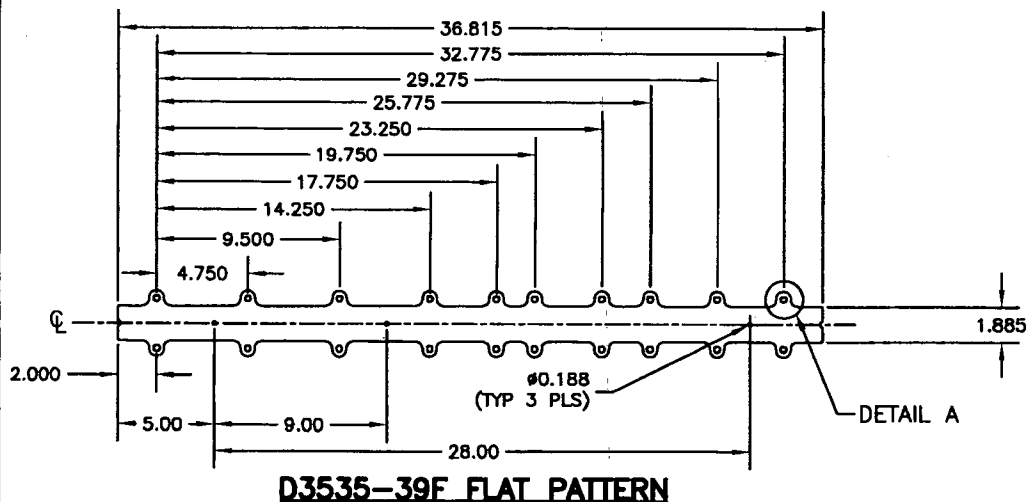
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 6 OF 7
		SCALE	1:10	



NOTES

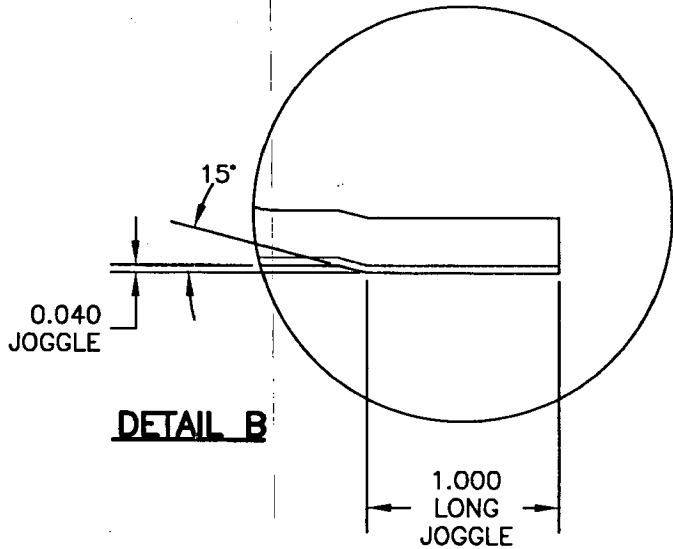
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- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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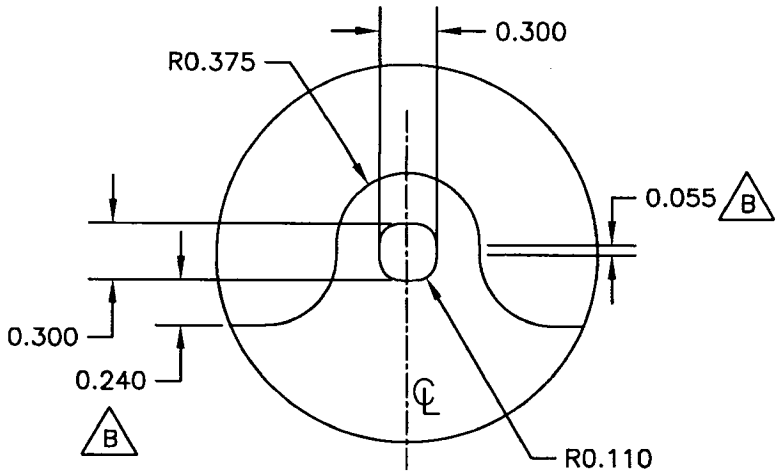


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DATE 07.04.17	TITLE WEARSHOE	SHEET 7 OF 7	SCALE 1:1

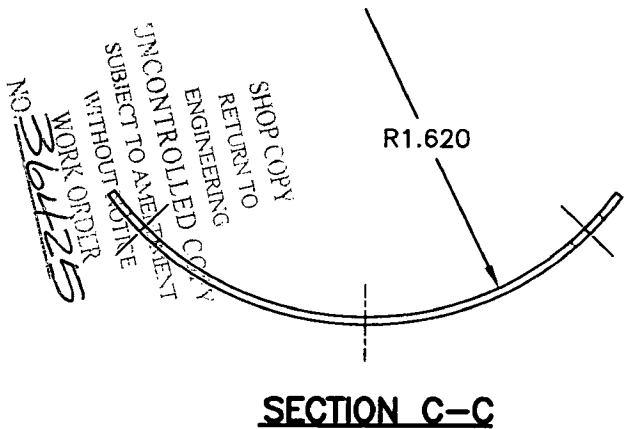
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DETAIL B



DETAIL A



SECTION C-C